



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D412-706-011
Job Sheet 179438



Part No: D412-706-011

Job Qty: 2 ea

Part Name: Fuel Purge Canister



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 6/19/18

Job Tracking No:

Due Date: 7/16/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV B SHEETS 19-20 IPP Rev:E 04.12.03 Remove AN6289-6D; Change Qty of 924-6D KJ/JLM IPP Rev:F 08-05-14 revise comment in seq.17 /24 DD verf:EC IPP rev G 10.01.18 per DSI9494 EC verified by:DD IPP Rev:H 10.03.23 as per IIN revA DD verified:EC IPP Rev:I 10.05.10 as per chg003 DD verified:EC IPP REV K 11.06.17 AS PER CHG 002 JLM VERIFIED:ec IPP Rev:L 12.12.07 as per IIN revB DD verified:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	2 Ea	7/16/18	7/16/18	0.00	0.00	Start Up Stores/Pkg-1		JUL 10 2018
110	Packaging	2 pcs	7/16/18	7/16/18	0.00	0.00	Packaging1-4		JUL 18 2018
120	QC	2 pcs	7/16/18	7/16/18	0.00	0.00	QC4		JUL 18 2018
130	Packaging	2 pcs	7/16/18	7/16/18	0.00	0.00	Packaging3-2		JUL 18 2018
135	DC	2 pcs	7/16/18	7/16/18	0.00	0.00	DC		JUL 18 2018
140	QC21-FG	2 Ea	7/16/18	7/16/18	0.00	0.00	QC21		JUL 18 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN3-5A	Bolt	8 Ea (4 ea)	90-Start up Operation	S071342
AN814-8D	Plug	2 Ea (1 ea)	90-Start up Operation	FM137851-3
AN815-6D	Union M Flare	4 Ea (2 ea)	90-Start up Operation	FM1379633
AN815-8D	Union-M-Flare	2 Ea (1 ea)	90-Start up Operation	FI24239
AN833-6D	Elbow, Bulkhead-M-Flare	4 Ea (2 ea)	90-Start up Operation	FM137820-3
AN833-8D	Elbow	2 pcs (1 ea)	90-Start up Operation	FM126475
AN924-6D	Nut	8 Ea (4 ea)	90-Start up Operation	S034390
AN924-8D	Nut	2 pcs (1 ea)	90-Start up Operation	S083532
AN938-6D	Tee	2 Ea (1 ea)	90-Start up Operation	S084115
D2001-4	Valve Assembly 1/4 Inch	2 Ea (1 ea)	90-Start up Operation	FI60652
D3262-043	Canister Assembly	2 Ea (1 ea)	90-Start up Operation	S091626
D3264-1	Bracket	4 Ea (2 ea)	90-Start up Operation	S079712x3
D3297-1-0098	Hose Assembly	2 Ea (1 ea)	90-Start up Operation	S069049x1
D3297-1-0121	Hose Assembly	2 Ea (1 ea)	90-Start up Operation	S069054
D3297-3-0210	Hose Assembly 21.00"	2 Ea (1 ea)	90-Start up Operation	F108120x1 F108120x1
D3298-005	Tube Assembly	2 Ea (1 ea)	90-Start up Operation	F157336x1
D3298-007	Tube Assembly	2 Ea (1 ea)	90-Start up Operation	F155469x1
D3299-3	Fitting	2 Ea (1 ea)	90-Start up Operation	FI60416x1
D3299-5	Fitting	2 Ea (1 ea)	90-Start up Operation	F80846
D3299-7	Fitting	2 Ea (1 ea)	90-Start up Operation	F95411x1
D3301-1	Placard	2 Ea (1 ea)	90-Start up Operation	S02180
D3301-3	Placard	2 Ea (1 ea)	90-Start up Operation	S02180
D3302-1	Doubler	2 Ea (1 ea)	90-Start up Operation	F137783x1

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval			
Description Work Order Deviation		Container No: S093316 Part: D412 - 706 - 011 Job No: 179438 Serial No/Batch: S093316 Revision: _____ Inspector: _____ Exp Date: _____ Instructions: _____ Date: 07/18/18					
						Completed By	
						Lead hand / Supervisor Approval Verification	
		QC / QA Coordinator Approval					
Root Cause		FAULT					
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Positioned Wrong ☐			
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Outside Dimensions ☐			
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Over/Under tolerance ☐			
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Part Incorrect ☐			
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Un ☐	Part Lost/Missing ☐			
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Part Moved ☐			
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Drawing ☐			
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Finish ☐			
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Misread ☐			
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Turning Sequence ☐			
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____					
Misidentified ☐	Past Due ☐						

D3302-3	Doubler	2 Ea (1 ea)	90-Start up Operation	5079329
D3329-1	Bushing	4 Ea (2 ea)	90-Start up Operation	F157303
D4054-001	Tube Assembly	2 Ea (1 ea)	90-Start up Operation	5082148x1
D4054-003	Tube Assembly	2 Ea (1 ea)	90-Start up Operation	5082479x1
D4054-009	Tube Assembly	2 Ea (1 ea)	90-Start up Operation	5083858
MS21042L3	Nut	8 Ea (4 ea)	90-Start up Operation	5078167
MS21919-WDG9	Clamp	4 Ea (2 ea)	90-Start up Operation	5034403
MS21920-42	Clamp	4 Ea (2 ea)	90-Start up Operation	F1138332x2
MS29512-06	O-Ring	14 pcs (7 ea)	90-Start up Operation	5027734x4 5056030X10
MS29512-08	O-Ring	6 pcs (3 ea)	90-Start up Operation	5006994
MS35489-16	Grommet	2 Ea (1 ea)	90-Start up Operation	F121255
NAS1149D0332J	Washer	8 Ea (4 ea)	90-Start up Operation	5035396
NAS1149D0363J	Washer	16 Ea (8 ea)	90-Start up Operation	5015269
NAS1149D0963J	Washer	4 Ea (2 ea)	90-Start up Operation	F1135671-5

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	AN3-5A	8	228	0
	AN814-8D	2	6	0
	AN815-6D	4	10	0
	AN815-8D	2	14	0
	AN833-6D	4	6	0
	AN833-8D	2	7	0
	AN924-6D	8	18	0
	AN924-8D	2	2	0
	AN938-6D	2	1	0
	D2001-4	2	3	0
	D3262-043	2	1	0
	D3264-1	4	5	0
	D3297-1-0098	2	2	0
	D3297-1-0121	2	4	0
	D3297-3-0210	2	3	0
	D3298-005	2	2	0
	D3298-007	2	2	0
	D3299-3	2	2	0
	D3299-5	2	18	0
	D3299-7	2	15	0
	D3301-1	2	6	0
	D3301-3	2	10	0
	D3302-1	2	2	0
	D3302-3	2	5	0
	D3329-1	4	19	0
	D4054-001	2	2	0
	D4054-003	2	0	0
	D4054-009	2	2	0
	MS21042L3	8	1,504	0
	MS21919-WDG9	4	80	0
	MS21920-42	4	4	0
	MS29512-06	14	27	0
	MS29512-08	6	56	0
	MS35489-16	2	4	0
	NAS1149D0332J	8	1,710	0
	NAS1149D0363J	16	2,025	0
	NAS1149D0963J	4	509	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					



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Container View (Active) - Master Unit Containers

Master Unit No	Container No	Part No	Part Name	From Container	Current Location	Quantity
004308	S090578	AN3-5A	Bolt	s071342	ST350	8
004308	S090577	AN814-8D	Plug	fm137851-3	ST326	2
004308	FM137963-3	AN815-6D	Union M Flare		ST325	4
004308	S090575	AN815-8D	Union-M-Flare	F124239	ST326	2
004308	S090573	AN833-8D	Elbow	fm126475	ST324	2
004308	S090571	AN924-6D	Nut	s034390	ST322	8
004308	S090570	AN924-8D	Nut	s083532	ST322	2
004308	S090569	AN938-6D	Tee	S084115	ST322	2
004308	F160652	D2001-4	Valve Assembly 1/4 Inch		ST001	2
004308	S079717	D3264-1	Bracket	S079714	ST493	3
004308	S092484	D3264-1	Bracket	s088974	ST493	1
004308	S069049	D3297-1-0098	Hose Assembly	S074529	ST209	1
004308	S090527	D3297-1-0098	Hose Assembly	S084024	ST209	1
004308	S069054	D3297-1-0121	Hose Assembly	S074558	ST209	2
004308	F108120	D3297-3-0210	Hose Assembly 21.00"		ST209	2
004308	F157336	D3298-005	Tube Assembly		ST210	1
004308	S092786	D3298-005	Tube Assembly	s092458	ST210	1
004308	F155469	D3298-007	Tube Assembly		ST210	1
004308	S092785	D3298-007	Tube Assembly	s092479	ST210	1
004308	F160416	D3299-3	Fitting		ST030	1
004308	F86846	D3299-5	Fitting		ST030	2
004308	F95411	D3299-7	Fitting		ST030	1
004308	S090518	D3299-7	Fitting	f109125-0	ST030	1
004308	S090563	D3301-1	Placard	S072186	ST030	2
004308	F137783	D3302-1	Doubler		ST494	1
004308	S092480	D3302-1	Doubler	s083597	ST494	1
004308	S092481	D3302-3	Doubler	s078329	ST494	2
004308	S090509	D3329-1	Bushing	F157303	ST031	4
004308	S082148	D4054-001	Tube Assembly	S082071	ST214	1
004308	S082479	D4054-003	Tube Assembly	S082427	ST214	1
004308	S090505	D4054-003	Tube Assembly	S083617	ST214	1
004308	S090503	D4054-009	Tube Assembly	S083858	ST214	2
004308	S090499	MS21042L3	Nut	s078167	Cycle Retire	8
004308	S090497	MS21919-WDG9	Clamp	s034403	ST293	4
004308	FM138332	MS21920-42	Clamp		ST546	2
004308	S092795	MS21920-42	Clamp	s090794	ST546	2
004308	S027734	MS29512-06	O-Ring		ST274	4
004308	S090490	MS29512-06	O-Ring	s056030	ST274	10
004308	S090485	MS29512-08	O-Ring	s006994	ST274	6
004308	S090482	MS35489-16	Grommet 25/pk	f121255	ST269	2
004308	S090480	NAS1149D0332J	Washer	s035396	ST264	8
004308	S090479	NAS1149D0363J	Washer	s015269	ST263	16
004308	S090471	NAS1149D0963J	Washer	fm135671-15	ST263	4

Note: Ad hoc query view of Part.dbo.Container where Container.Active = 1.

Plex 7/17/18 1:45 PM dart.quirion.sonia

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JUL 18 2018

5. PARTS LIST

Qty -011	Qty -013	Qty -015	Part Number	Description
X			D412-706-011	FUEL PURGE CANISTER INSTALLATION (212/412)
	X		D205-706-013	FUEL PURGE CANISTER INSTALLATION (205/214/EAGLE SINGLE)
		X	D204-706-015	FUEL PURGE CANISTER INSTALLATION (204)
1	1	1	D2001-4	VALVE ASSEMBLY
		2	D2026-101	SCREW
	1	1	D3262-041	CANISTER ASSEMBLY
1			D3262-043	CANISTER ASSEMBLY
2	2	2	D3264-1	BRACKET
1			D3297-1-0098	HOSE ASSEMBLY
1	1		D3297-1-0121	HOSE ASSEMBLY
	1		D3297-1-0130	HOSE ASSEMBLY
1			D3297-3-0210	HOSE ASSEMBLY
	1		D3297-3-0350	HOSE ASSEMBLY
		1	D3297-5-0410	HOSE ASSEMBLY
	1		D3298-001	TUBE ASSEMBLY
1			D3298-005	TUBE ASSEMBLY
1			D3298-007	TUBE ASSEMBLY
	1		D3298-009	TUBE ASSEMBLY
		1	D3298-011	TUBE ASSEMBLY
		1	D3298-013	TUBE ASSEMBLY
		1	D3298-015	TUBE ASSEMBLY
	1	1	D3299-1	FITTING
1	1		D3299-3	FITTING
1			D3299-5	FITTING
1			D3299-7	FITTING
1	1	1	D3301-1	PLACARD
1	1	1	D3301-3	PLACARD
1	1		D3302-1	DOUBLER
1	1		D3302-3	DOUBLER
		1	D3302-5	DOUBLER
		2	D3302-7	DOUBLER
2			D3329-1	BUSHING
1			D4054-001	TUBE ASSEMBLY
1			D4054-003	TUBE ASSEMBLY
1			D4054-009	TUBE ASSEMBLY
4	4	4	AN3-5A	BOLT
	1	1	AN814-6D	PLUG
1			AN814-8D	PLUG
2	2	2	AN815-6D	UNION
1			AN815-8D	UNION
		1	AN816-6D	NIPPLE
2	3	1	AN833-6D	ELBOW

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Date: 12.11.06

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9-89

Qty -011	Qty -013	Qty -015	Part Number	Description
1			AN833-8D	ELBOW
		1	AN919-6D	REDUCER
4	4	1	AN924-6D	NUT
1			AN924-8D	NUT
1			AN938-6D	TEE
4	4	2	AN960JD10L	WASHER
8	8	8	AN960JD10	WASHER
2	2		AN960JD916	WASHER
4	4	4	MS21042L3	NUT
	1	1	MS21919WDG12	CLAMP
	2		MS21919WDG16	CLAMP
		2	MS21919WDG6	CLAMP
		3	MS21919WDG7	CLAMP
2	5		MS21919WDG9	CLAMP
2	2	2	MS21920-42	CLAMP
7	5	5	MS29512-06	O-RING (OR M83248/1-906)
3			MS29512-08	O-RING (OR M83248/1-908)
	1	1	MS35489-11	GROMMET
1			MS35489-16	GROMMET

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